

# Work Order ID 74912

**\*74912\***

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Thursday, October 13, 2011 12:26:05 PM

Item ID: D3913-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Long Basket Base Assembly, 350  
 Start Date: 10/13/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 10/19/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: ✓ Date: 11-10-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3913	A								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <u>4115778</u>	0.00							
<b>*100*</b>	Large Fab								
Large Fab	<b>Memo</b>	0.00							
	1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

11/10/24 (1x)

11-10-25

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
<b>*130*</b>									
Powdercoat									
Powder Coating									

**Memo**  
1 - Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT: 11:00  
START TIME: 4:00  
OVEN TEMPERATURE: 0F  
FINISH TIME: 11:30  
\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:  
START TIME: \_\_\_\_\_  
OVEN TEMPERATURE: \_\_\_\_\_  
FINISH TIME: \_\_\_\_\_

140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC									
Quality Control									

**Memo**  
0.00

M117745

*Handwritten signature and date: 11/10/2011*

*Handwritten signature and date: 11/10/2011*

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Pick Kit								
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

11/10/25

Sub 6

70

D4030-041 / 1374911

1 0 11/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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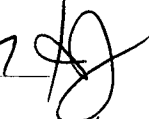
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

11/10/27   
ME  
11-10-26

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D2581

Manufactured No

100

Each

35.0000

2

2

**\*D2581\***

Mounting Bracket

\*\*

*11/10/19*

Location

Loc Qty

Loc Code

WA

35

69739

2

70766

2

73079

10

73762

21

✓ D3913-1

Manufactured No

100

Each

6.0000

1

1

**\*D3913-1\***

Rib

\*\*

*11/10/19*

Location

Loc Qty

Loc Code

WA

6

59089

1

69260

2

74145

3

✓ D3913-15

Manufactured No

100

Each

11.0000

1

1

**\*D3913-15\***

Wide Handle Plate

\*\*

*11/10/19*

Location

Loc Qty

Loc Code

WA

10

74317

2

74640

8

WA005

1

69012

1

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-3  
**\*D3913-3\***  
Rib

Manufactured No

100 Each

5.0000

1

1

\*\*

*Handwritten signature* 11/10/19

Location

Loc Qty

Loc Code

WA

5

69160

1

73533

1

74144

3

100 Each

8.0000

2

\*\*

*Handwritten signature* 11/10/19

Location

Loc Qty

Loc Code

WA

2

69521

2

WA006

6

65278

1

66435

1

73648

4

100 Each

5.0000

1

\*\*

*Handwritten signature* 11/10/19

✓ D3913-9  
**\*D3913-9\***  
Hinge Rib

Manufactured No

Location

Loc Qty

Loc Code

WA

4

73530

1

74143

3

WA006

1

70138

1

*Handwritten signature* 11/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 74912

**\*74912\***

Parent Item: D3913-041

**\*D3913-041\***

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3916-041

Manufactured No

100 Each

6.0000

2 2

✓ **\*D3916-041\***

Rib Assembly

\*\*

1 *dy* 11/10/19

Location

Loc Qty

Loc Code

WA

6

69161

2

74131

4

(2x)

D3916-5

Manufactured No

100 Each

4.0000

3

✓ **\*D3916-5\***

Light Rib

\*\*

374920 (2x) *dy* 11/10/19

Location

Loc Qty

Loc Code

WA

4

73637

2

74639

2

(1x)

D4016-1

Manufactured No

100 Each

28.0000

3

✓ **\*D4016-1\***

Hinge Half, Base

\*\*

*dy* 11/10/19

Location

Loc Qty

Loc Code

WA

28

66418

0

68426

3

72757

7

74140

18

(3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D3913-041\***

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7 Manufactured No

100 Each

9.0000

1

1

\*\*

*11/10/19*

**\*D4017-7\***

Rib

## Location

## Loc Qty

## Loc Code

WA

7

69730

1

74638

6

WA005

2

74077

2

D4017-9 Manufactured No

100 Each

12.0000

2

\*\*

*11/10/19*

**\*D4017-9\***

Rib

## Location

## Loc Qty

## Loc Code

WA

6

70341

2

73531

4

WA006

6

74141

6

D4020-11 Manufactured No

100 Each

5.0000

2

\*\*

*B74386 11/10/20*

**\*D4020-11\***

End Mesh, Basket

## Location

## Loc Qty

## Loc Code

WA

5

69648

2

74035

3

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1

Manufactured No

100 Each

21.0000

3 3

\*\*

*SW 11/10/19*

✓ **\*D4021-1\***  
Handle Plate

Location	Loc Qty	Loc Code
WA	18	
69518	6	
74316	12	
WA005	3	
73649	3	

(3)

D4034-041

Manufactured No

100 Each

4.0000

1 1

\*\*

*SW 11/10/19*

✓ **\*D4034-041\***  
Aft Upper Rib Assembly

Location	Loc Qty	Loc Code
WA006	4	
69157	1	
74139	3	

(1)

D4034-043

Manufactured No

100 Each

4.0000

1 1

\*\*

*SW 11/10/19*

✓ **\*D4034-043\***  
Fwd Upper Rib Assembly

Location	Loc Qty	Loc Code
WA	3	
74146	3	
WA006	1	
70241	1	

(1)

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Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

✓ M304EX0.75-16F

Purchased

No

100

sf

779.7855

33

33

**\*M304EX0 75-16F\***

Expanded Metal Flat SS

\*\*

*11/10/20*

## Location

## Loc Qty

## Loc Code

WA

779.78548

117197

102.9036

117896

53.3264

118153

82.2683

118248

33.0983

118597

73.01888

118955

115.17

119180

320

*33*

AN3-10A

Purchased

No

150

Each

167.0000

6

6

**\*AN3-10A\***

Bolt

\*\*

*6*

## Location

## Loc Qty

## Loc Code

GA

100

119084

100

ST351

67

~~117795~~

51

119128

16

*6*

AN960JD8

NAS1149DN832

Purchased

No

150

Each

0.0000

2

2

**\*AN960JD8\***

Washer

\*\*

*11/17/87*

D2931

Manufactured

No

150

Each

572.0000

2

2

**\*D2931\***

Bumper

\*\*

*11/10/20*

## Location

## Loc Qty

## Loc Code

ST504

572

46064

572

*2*

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Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each 29.0000 2

**\*D4021-5\***

Blanking Plate

\*\*

Location

Loc Qty

Loc Code

GA

29

73478

29

MS20600-AD4W3

Purchased

No

150 Each

1,417.000 2

**\*MS20600-AD4W3\***

Cherry Rivets

\*\*

Location

Loc Qty

Loc Code

GA

882

118626

882

ST321

402

111636

48

117505

319

117601

35

WA018

133

107939

133

MS21042L3

Purchased

No

150 Each

10,396.00 6

**\*MS21042L3\***

Nut

\*\*

Location

Loc Qty

Loc Code

ST300

1396

117441

16

117885

91

118451

341

118927

948

ST516

6000

119017

6000

ST518

3000

119075

3000

W/O:		WORK ORDER CHANGES					
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Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

428.0000

12

**\*NAS1149F0332P\***

WASHER

\*\*

11/18/2011

Location

Loc Qty

Loc Code

ST275

428

117735

45

119225

380

17317

3

12

Thursday, October 13, 2011 12:26:11 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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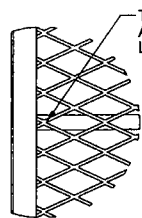
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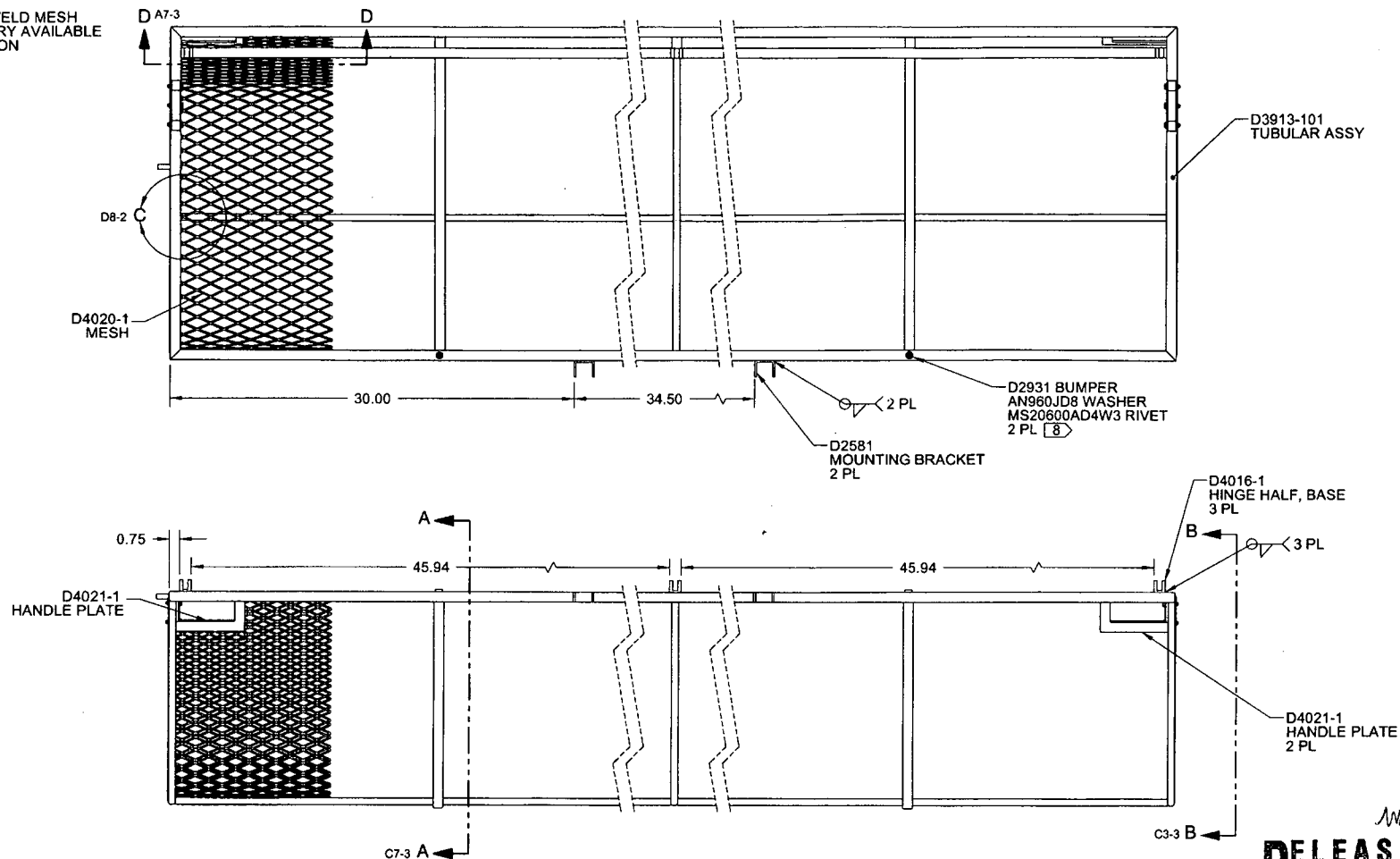
**NOTE:** Date & initial all entries

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**DETAIL C** D7-2



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-02-27

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<del>AK</del>	D3913	SHEET 2 OF 6
APPROVED	<del>AK</del>	TITLE	SCALE
DE APPR.	<del>AK</del>	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

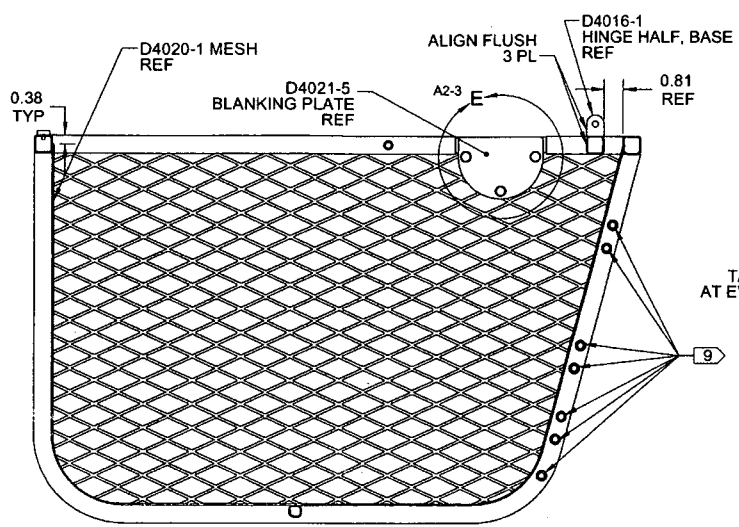
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

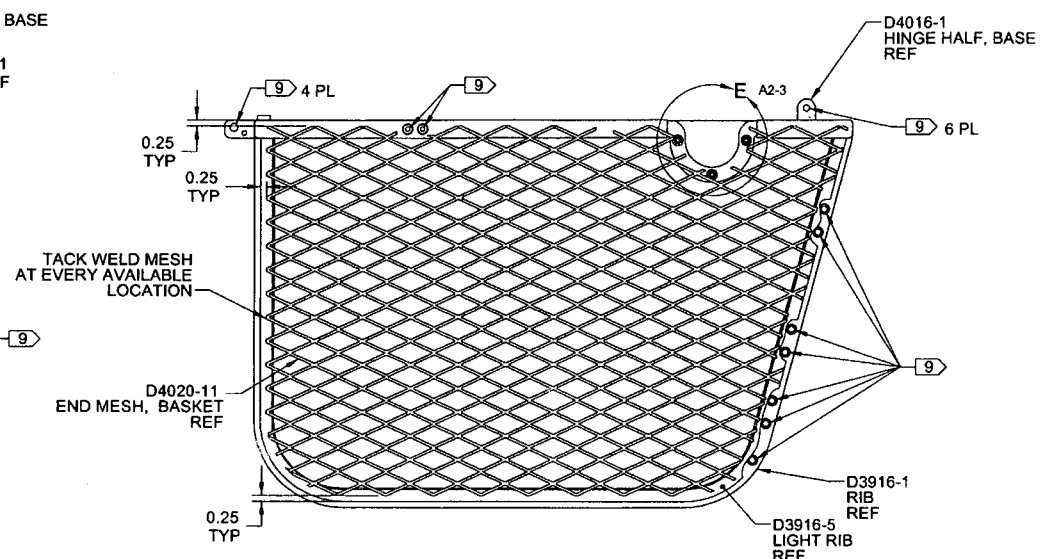
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

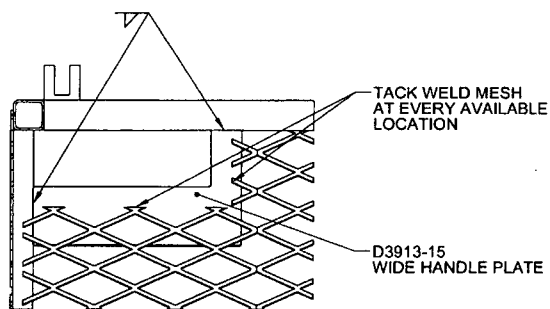
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**SECTION A-A** A5-2

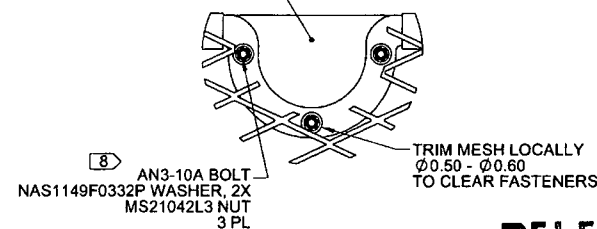


**VIEW B-B** A2-2







**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES

**DETAIL E** D2-3  
D6-3



**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

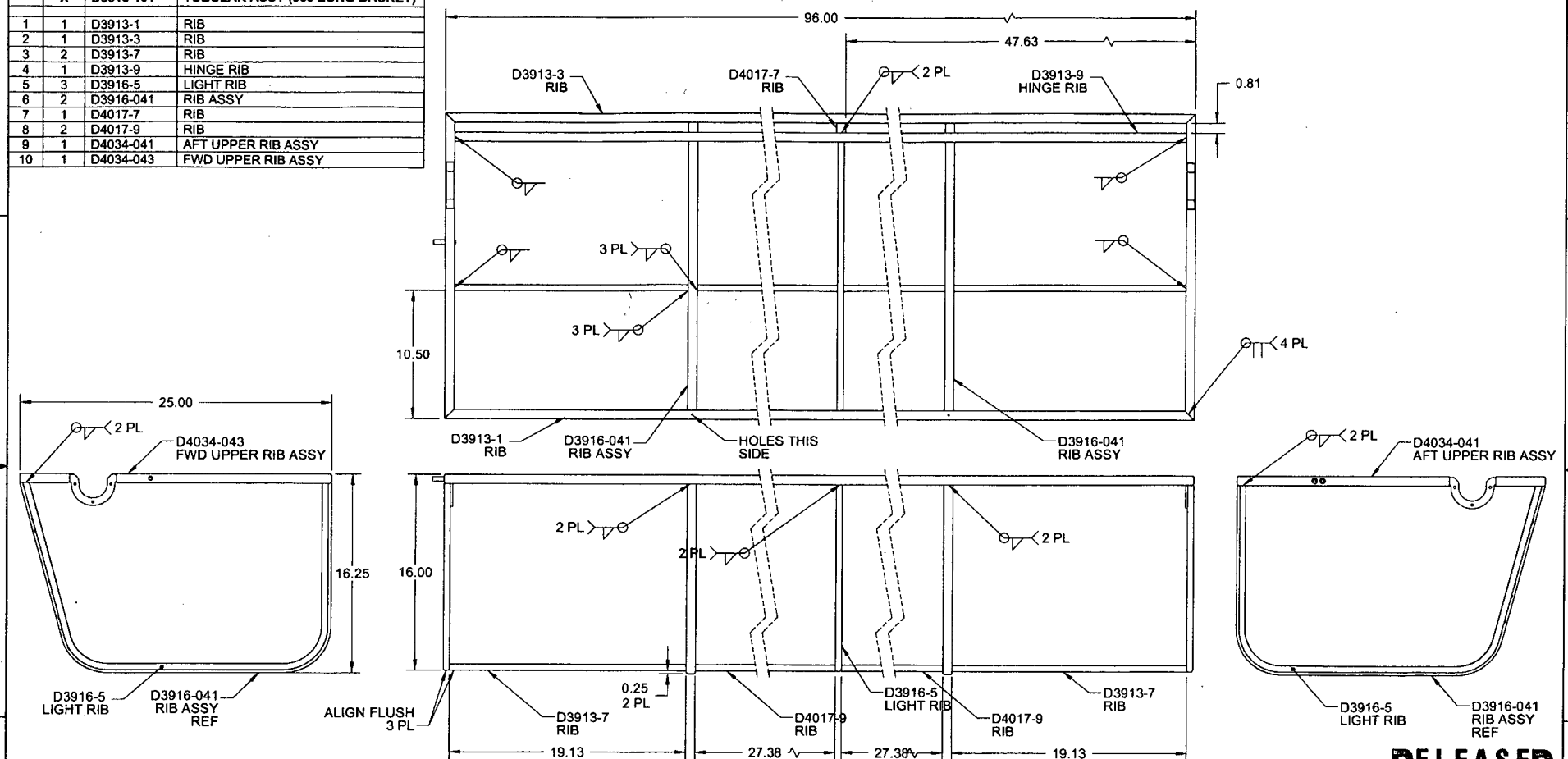
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 22.53 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
  - 9) WELD PER DART QSI 004

RELEASED  
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3913
MFG. APPR.		REV. A
APPROVED		SHEET 4 OF 6
DE APPR.		TITLE LONG BASKET BASE ASSY (350) NTS
DATE	10.03.16	SCALE

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

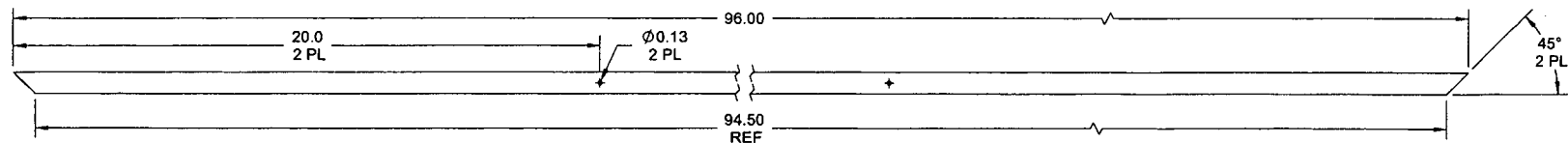
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

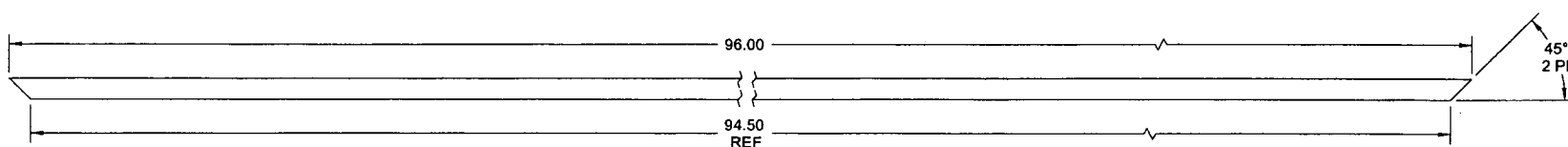
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

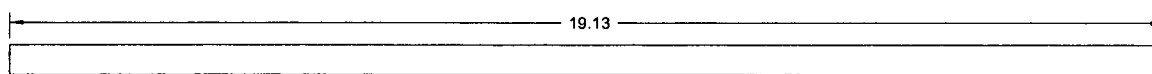
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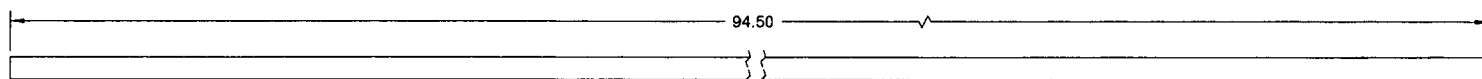
**D3913-1 RIB**



**D3913-3 RIB**



**D3913-7 RIB**



**D3913-9 HINGE RIB**





**NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2010-03-22

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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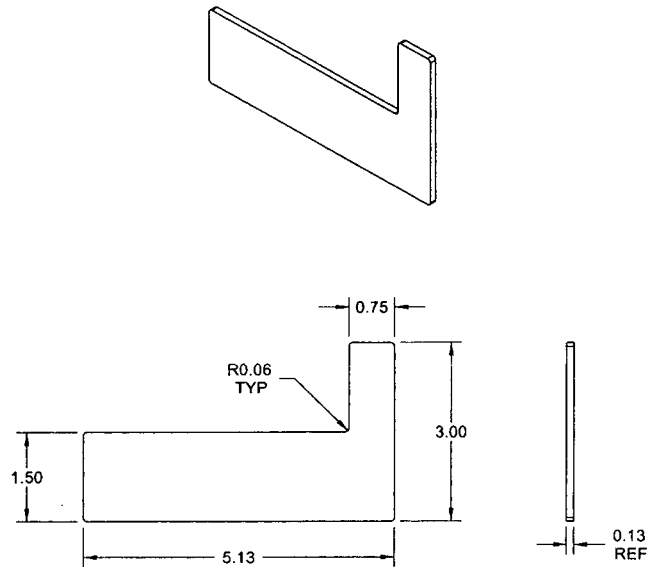
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2010-03-22  
JAH

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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